

Work Order ID 103944

103944

Page 1

July-08-13 7:04:09 AM

Item ID: D500-560-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Mirror Installation

Start Date: 7/08/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/09/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00

100

DOCUMENT CONTROL

DC

Memo M.D.

0.00

Document Control

Photocopy bluefile and create labels as per PPP D500-560-041 CHG006

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per drawing D500-560
PAGE 8- BLUE FILE

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

13/2/10

DAS
06
9-89

④ 13-7-10

4 13-07-08

4

13 7.8

DQA: ADL Date: 13/08/18QA Closed: ADL Date: 13/08/18

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>D500-560-041</u> Part No. <u>B103944</u> NCR No. <u>13-2918</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input checked="" type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

Design: 13/07/18 110 2 D2011-101 minor new scrap D2829 at broke when the assembly
 Material: D2011-101 B89784
 Process: (2x) Stud machine at top RC stud machine at 100 tolerance at TOL.
 Initial Chief Eng: DAS 15 9-33
 Action Description: Scrap = destroy replace by D2011-101 B100741 B89784
 Sign & Date: 13/07/18 FF.
 Verification: B7-8
 QC Inspector: DAS 9-33 022042 13/07/22
 Cost: \$39.49
 Date: 13.08.06

FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function
	<input type="checkbox"/> Folio/Program
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete/Unqualified
	<input type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Misaligned/off center
	<input type="checkbox"/> Mislabeled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Off-set
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Set-up
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

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Item ID: D500-560-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Mirror Installation

Start Date: 7/08/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/09/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00				4x		11.10.13-07-9	
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D500-560-041								
	Location: 042								
	PPP Rev: C								

DAS
06
9-09

13/7/10

4

4 13/7/10

54

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103944

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13/7/11

307-11

Picklist Print

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Page 1

Work Order ID: 103944
 Parent Item: D500-560-041
 Parent Item Name: Cargo Mirror Installation

Start Date: 7/08/13

Required Date: 7/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
 IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G 10.04.22 chg route seq
 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-01 Bolt		Purchased	No			140	Each	665.0000	4	16		13-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		124							
				120308		80							
				122814		38							
				124858		6							
				ST512		541							
				120770		3							
				123900		1							
				125445		537							
AN526C1032R10 Screw		Purchased	No			110	Each	69.0000	4	16		FF 13-07-08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		43							
				108062		43							
				ST346		26			16				
				114494		26							
D1048 Clamp		Manufactured	No			110	Each	36.0000	2	8		FF 13-07-08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		36							
				76951		4			4				
				97941		32			4				

Picklist Print

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Work Order ID: 103944
 Parent Item: D500-560-041
 Parent Item Name: Cargo Mirror Installation

Start Date: 7/08/13 Required Date: 7/09/13
 Start Qty: 4.00 Required Qty: 4.00

D1049	Manufactured	No	110	Each	40.0000	2	8	FF 13-07-08
Saddle								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		GA	40					
		94046	16					
		99603	24					
D2010-101	Manufactured	No	110	Each	9.0000	1	4	FF 13-07-08
Mirror Bracket 369/500								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST220	9					
		67369	3					
		98507	6					
D2010-103	Manufactured	No	110	Each	9.0000	1	4	FF 13-07-08
Mirror Arm 369/500								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST220	9					
		69620	1					
		90001	2					
		93219	6					
D2011-101	Manufactured	No	110	Each	66.0000	1	4	FF 13-07-08
MIRROR								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST179	50					
		100741	50					
		ST229	16					
		89784	6					
		98267	10					

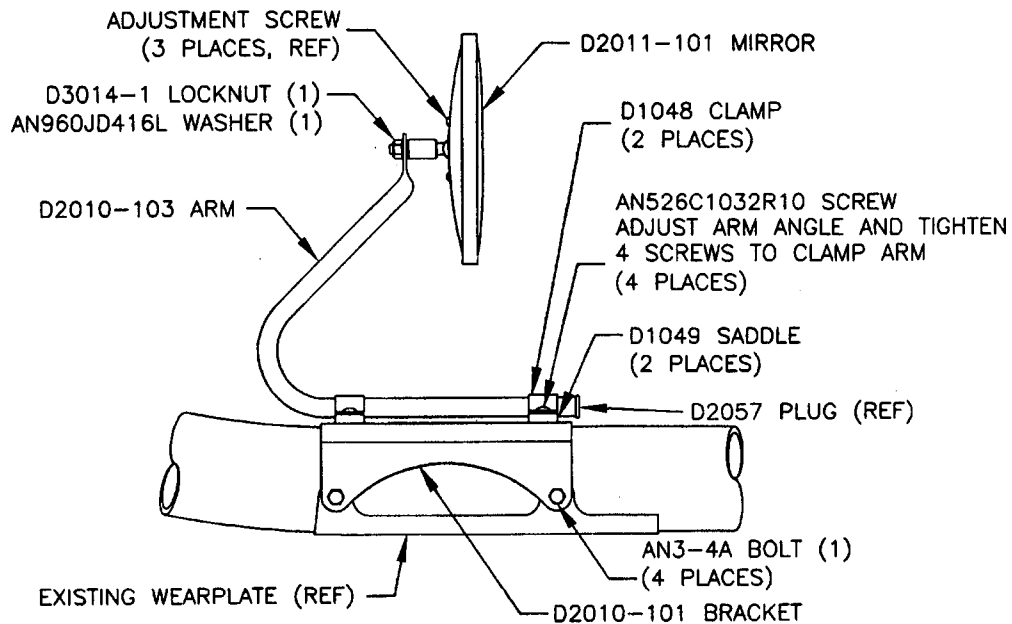


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041	1.0 lb	-45 in	-45 lb-kG	24 in	24 in-lb
Cargo Mirror Assembly	0.45 kg	-1.14 m	-0.51 m-kG	0.61 m	0.27 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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Revision: D
 Date: 01.04.24

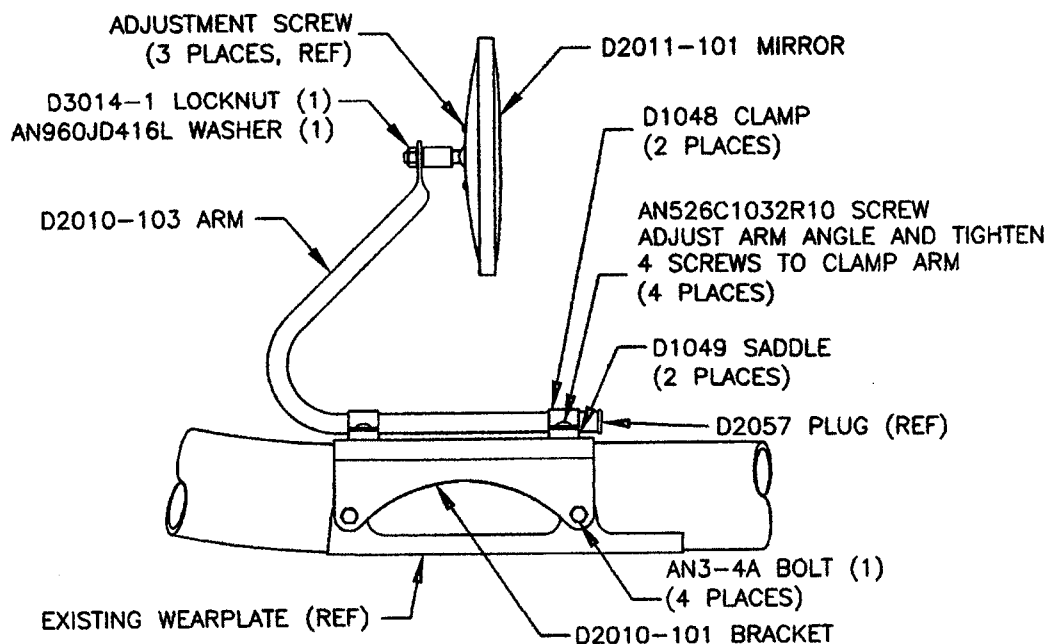
**REFERENCE ONLY**

Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041 Cargo Mirror Assembly	1.0 lb 0.45 kg	-45 in -1.14 m	-45 lb-kg -0.51 m-kg	24 in 0.61 m	24 in-lb 0.27 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT/
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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